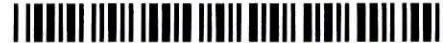




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A94-2706-00
Job Sheet 172440



417 22

Part No: RBE350A94-2706-00

Job Qty: 3 ea

Part Name: Rigging Pin Set



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/16/18

Job Tracking No:

Due Date: 3/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A94-2706-00 REV 6 IPP REV A 18-01-16 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		3/8/18	0.00	0.00	Start Up Small Fab-2		MLL
110	Small Fab	3 pcs		3/9/18	0.00	0.30	Small Fab-3		MLL DAS
120	QC	3 pcs		3/9/18	0.00	0.00	QC5		38
130	Packaging	3 pcs		3/9/18	0.00	0.00	Packaging3-1		MLL 9-80
140	QC21-SA	3 Ea		3/9/18	0.00	0.00	QC21	DAS 53 9-80	JUL 30 2018

Part Op
Descriptions: 110 - -Pick, bag and tag

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE350A94-2706-00-01	Pin	12 Ea (4 ea)	90-Start up Operation	5090530
RBE350A94-2706-00-03	Pin	6 Ea (2 ea)	90-Start up Operation	5090587
RBE350A94-2706-00-05	Pin	3 Ea (1 ea)	90-Start up Operation	5090597
RBE350A94-2706-00-07	Pin	3 Ea (1 ea)	90-Start up Operation	5090595
RBE350A94-2706-00-09	Pin	3 Ea (1 ea)	90-Start up Operation	5090592

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBE350A94-2706-00-01	12	0	0
	RBE350A94-2706-00-03	6	0	0
	RBE350A94-2706-00-05	3	0	0
	RBE350A94-2706-00-07	3	0	0
	RBE350A94-2706-00-09	3	0	0

Part Specifications

Specifications could not be found.

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐	
NCR No. _____	Suspected Unapproved ☐					

Date : _____ Step #: _____ QTY Effective : _____

MRB (QS1042) Approval

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause		 Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL : 1 613 632-6200 Email: sales@dartaero.com www.dartaerospace.com	
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Container No: S097114
Part: RBE350A94-2706-00
Job No: 172440
Serial No/Batch: S097114
Revision: 6
Inspector:
Exp Date:
Instructions:

Date: 07/27/18

Heat Treat ☐
Wave/Twist in Tube ☐
Marks/Chatter ☐
Drill Hole ☐

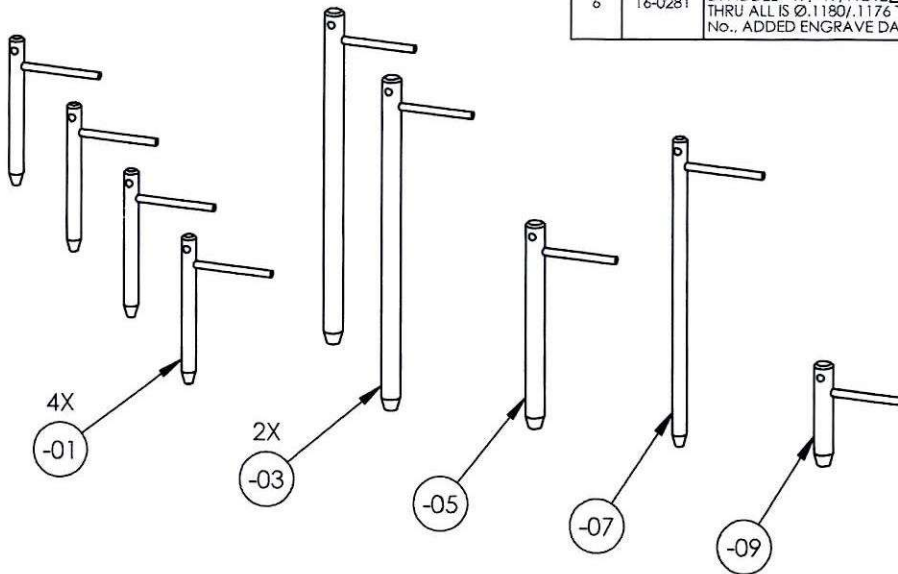
OTHER : _____

Positioned Wrong
Outside Dimensions
Over/Under tolerance
Part Incorrect
Part Lost/Missing
Part Moved
Drawing
Finish
Misread
Turning Sequence

ater

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		DESIGNED PER HELI PRODUCTS TOOLS.	9/11/2009	WP	DW
2		ADDED ONE MORE -03 PIN, FLAG AND CABLE TIE.	6/14/2010	WP	DW
3		MOVED LENGTH B DIMENSION TO Ø.118in. HOLE CENTERLINE & ADDED 1.5mm TO -01 THRU -09 PINS IN TABLE. ADDED A TOLERANCE TO Ø.118in. HOLE TO ACHIEVE A LIGHT PRESS FIT FOR -11. CH'D HOLE FROM Ø.118 TO Ø.113 FOR CABLE TIES. END OF PIN PER S.E.	12/15/2010	RJC	RW
4		CORRECTED PIN VIEW SHEET 1 AND CH'D Ø.113 [Ø2.9mm] HOLE TO Ø.118 [Ø3.0mm] PER G.E.	5/9/2012	RJC	GE
4A		CH'D T/N WAS RBEA94-2706-00 IS RBE350A94-2706-00.	11/6/2013	RJC	RW
5	15-0120	UPDATED TO NEW DRAFTING STANDARDS. CH'D TOLERANCE BLOCK WAS .XXX ± .004 IS .XXX ± .005. ADDED P/N'S -01A, -03A, -05A, -07A, -09A. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	5/26/2015	DPD	JAG
6	16-0281	UPDATED TO DRAFTING STANDARD. -01, -03, -05, -07, -09 ADDED FINISH SPEC QSMI-6.2.2, B.O. REV D. ADDED -17, -19, NOTE Δ -01A, -03A, -05A, -07A, -09A CH'D DIM WAS 2X Ø.118 ± .001/-000 THRU ALL IS Ø.1180/.1176 THRU ALL (P.F. -11). ADDED DIM Ø.12 THRU ALL. ADDED ENGRAVE DASH No., ADDED ENGRAVE DASH No. COLUMN TO TABLE.	1/12/2017	RJC	JAG



ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				X		-01	4	PIN			2
				1		-01A		PIN SHAFT	O-1	Ø6mm X 3 FT (MCMASTER-CARR #88625K65) MODIFIED	3
			X			-03	2	PIN			2
			1			-03A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMASTER-CARR #88625K67) MODIFIED	3
		X				-05	1	PIN			2
		1				-05A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMASTER-CARR #88625K67) MODIFIED	3
	X					-07	1	PIN			2
	1					-07A		PIN SHAFT	O-1	Ø6mm X 3 FT (MCMASTER-CARR #88625K65) MODIFIED	3
X						-09	1	PIN			2
1						-09A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMASTER-CARR #88625K67) MODIFIED	3
1	1	1	1	1	B/O	-11		DOWEL PIN	STEEL	Ø3mm X 40mm (MCMASTER-CARR #91595A142)	2
					B/O	-13	1	RE-SEALABLE PLASTIC BAG		5 IN X 6 IN APPROX.	N/S
A/R	A/R	A/R	A/R	A/R	B/O	-15		LOCTITE 680			2
1	1	1	1	1	B/O	-17		FLAGS, REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	2
1	1	1	1	1	B/O	-19		CABLE TIE	BLACK NYLON	(MCMASTER-CARR #7189K31)	2
ASSY -09	ASSY -07	ASSY -05	ASSY -03	ASSY -01							

		TITLE	
		RIGGING PIN SET	
DWG NO.		REV	
RBE350A94-2706-00		6	
MATERIAL		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
DRAWN BY: PERRITT		.X ± .1 SURFACES = 125/	
CHECKED: DUERFELDT		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 1:3		3. INTERPRET DIM AND TOL PER	
DATE 9/11/2009		ASME Y14.5M-2009	
SHEET 1 OF 3		USED ON MODEL	
		EUROCOPTER AS350/355	